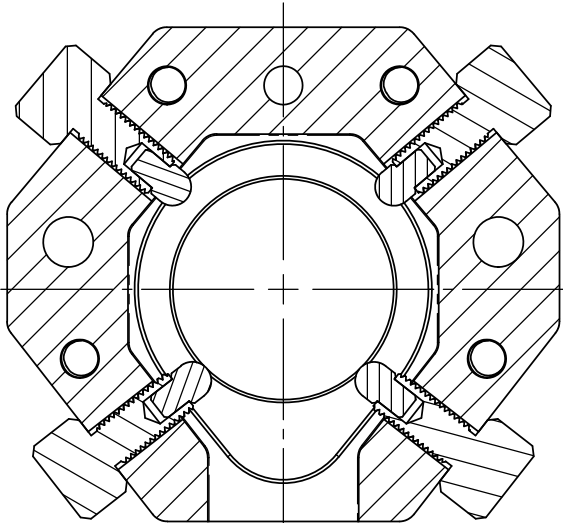
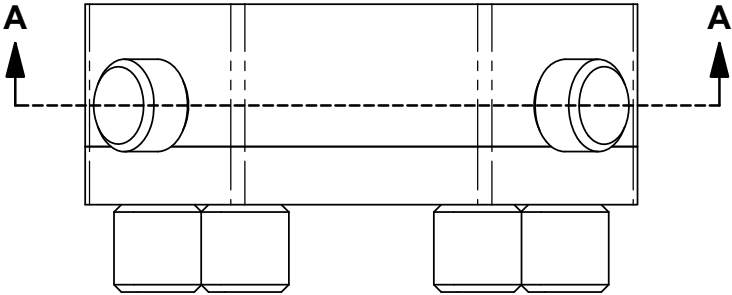
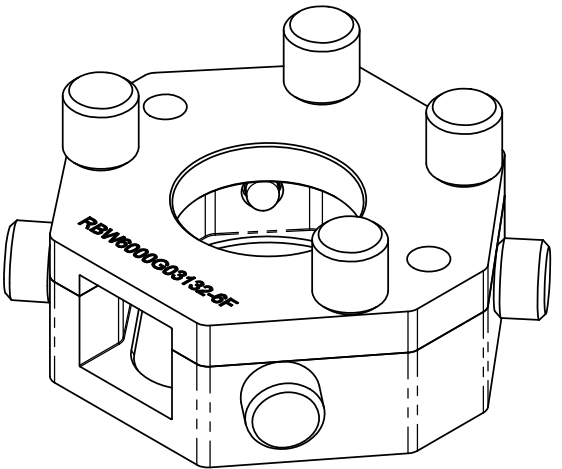
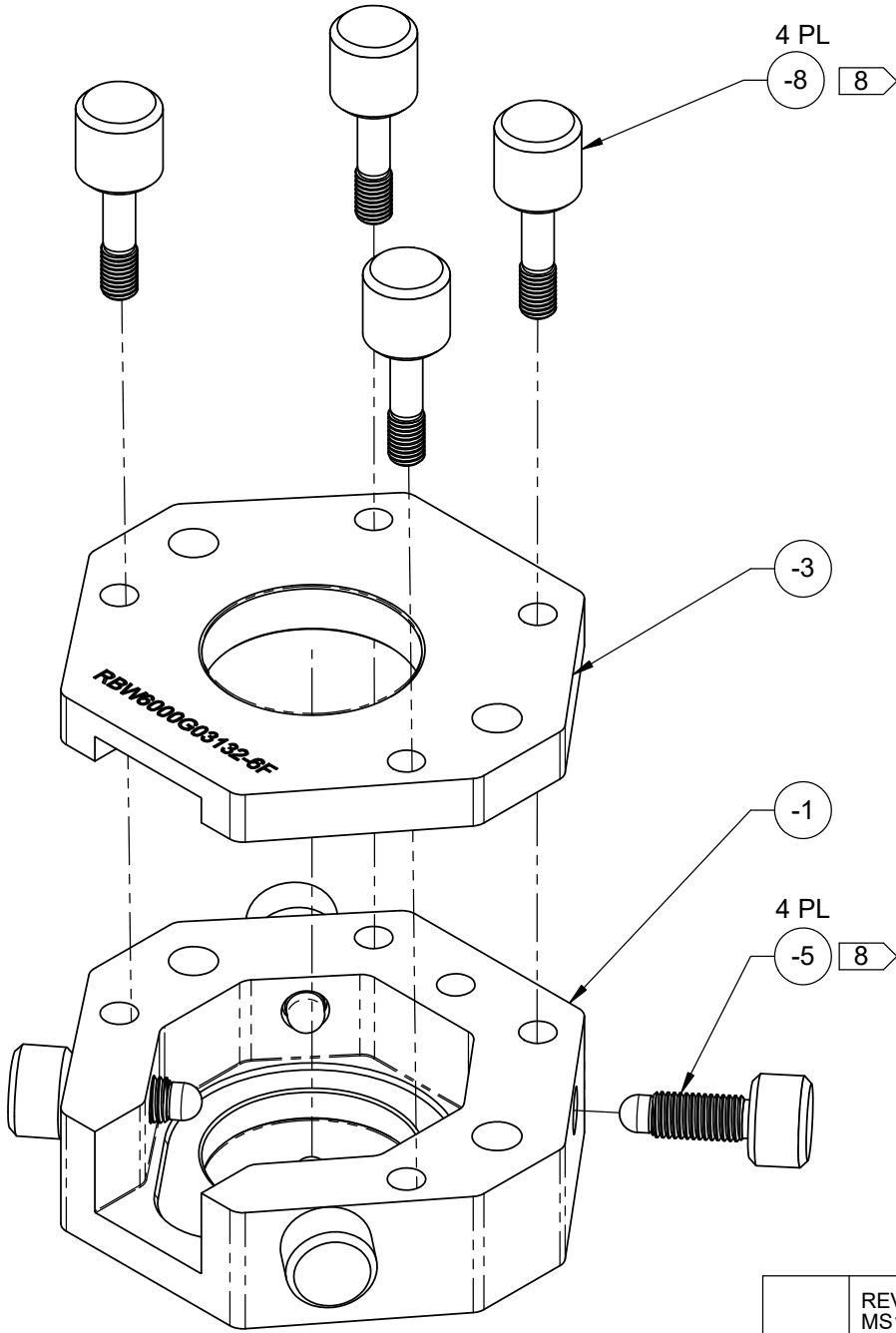


ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6000G03132-6F-1	TOP HALF ASSY
-3	1	RBW6000G03132-6F-3	BOTTOM HALF ASSY
-5	4	RBW6000G03132-6F-5	ALIGNMENT PIN ASSY
-8	4	RBW6000G03132-6F-8	SCREW



SECTION A-A

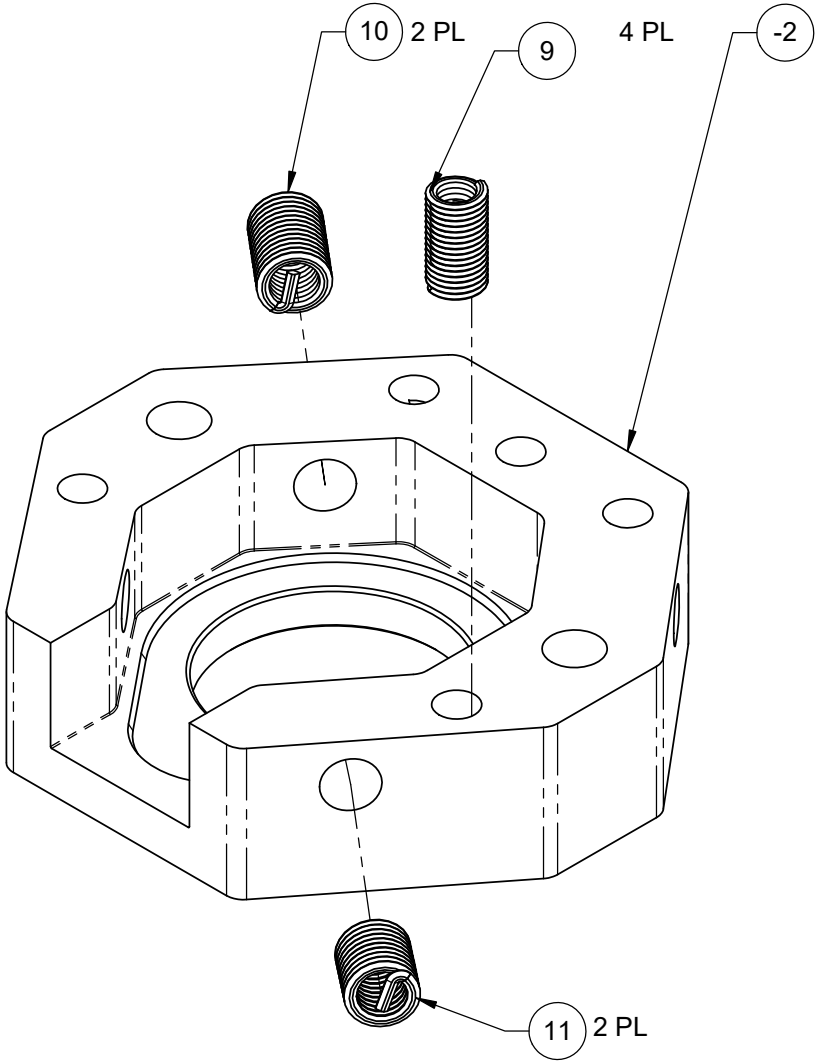


RBW6000G03132-6F PITCH LINK VISE ASSY

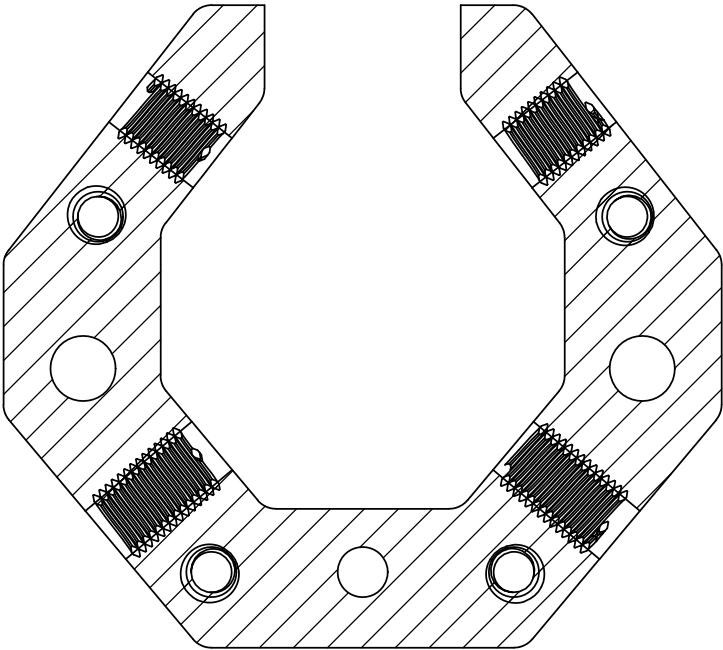
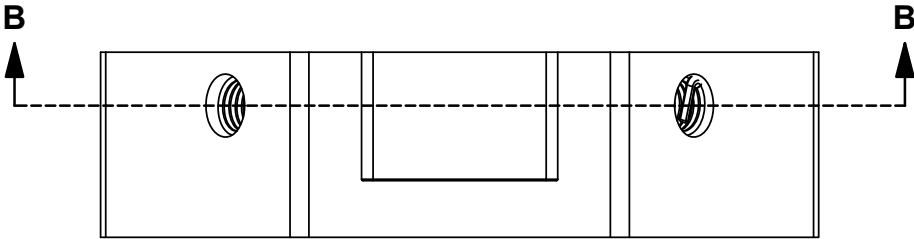
- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) INSTALL ITEM -5 AND ITEM -8 HAND TIGHT
 - 9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

B	REVISED DIM. FOR RBW6000G03132-6F-2/-4. REVISE HELICOIL P/N: MS124776 WAS MS21209F4-25, MS124737 WAS MS21209F5-20, MS124697 WAS MS21209F5-15 AND REVISED NOTE 7 FOR RBW6000G03132-6F-3/-4. MS124696 WAS MS21209F4-15 AND REVISED NOTE 7 FOR RBW6000G03132-6F-3. REVISED -6/-8 TO ADDED CLASS 3A TO THREAD TOLERANCE. REVISED -2/-4 ADDED CENTER TO CENTER TOLERANCES; REASON ECR 349		ECR 349	RF
A	NEW ISSUE		19-860	VM
REV.	DESCRIPTION		ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	RB	TOOL PART #		REV. B
MFG. APPR.	DD	RBW6000G03132-6F		SHEET 1 OF 9
APPROVED	SAD	TITLE		SCALE
DATE 6/28/2022		PITCH LINK VISE ASSY		NTS
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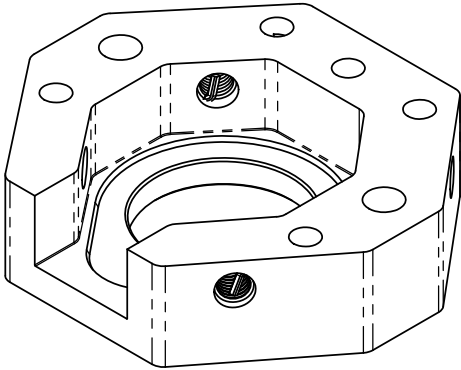
ITEM #	QTY	PART #	PART TITLE
-2	1	RBW6000G03132-6F-2	TOP HALF
9	4	MS124776	18-8 SS HELICAL INSERT 1/4"-28 X 5/8" LG. (FREE RUNNING)
10	2	MS124737	18-8 SS HELICAL INSERT 5/16"-24 X 5/8" LG. (FREE RUNNING)
11	2	MS124697	18-8 SS HELICAL INSERT 5/16"-24 X .469" LG. (FREE RUNNING)



RBW6000G03132-6F-1 TOP HALF ASSY

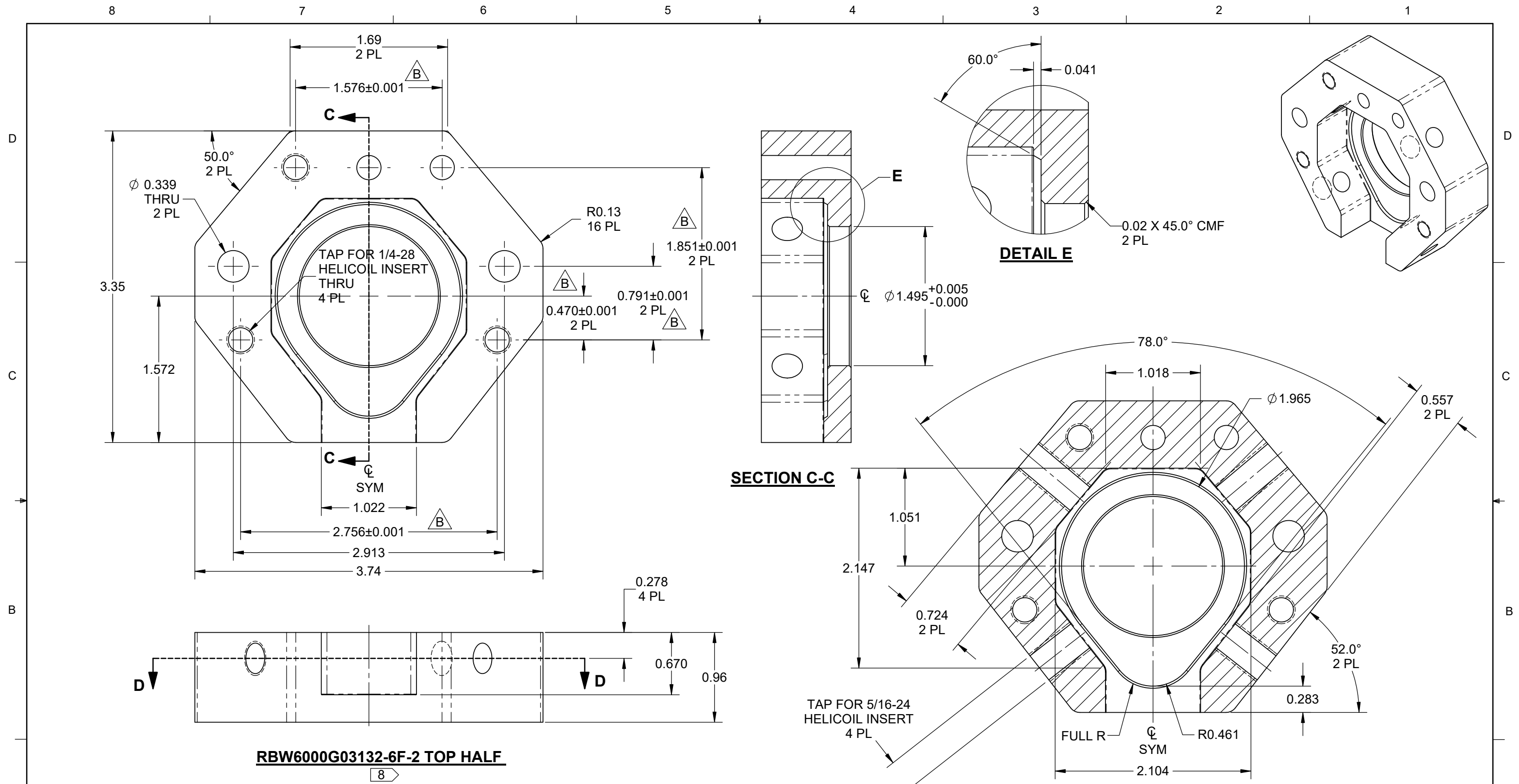


SECTION B-B



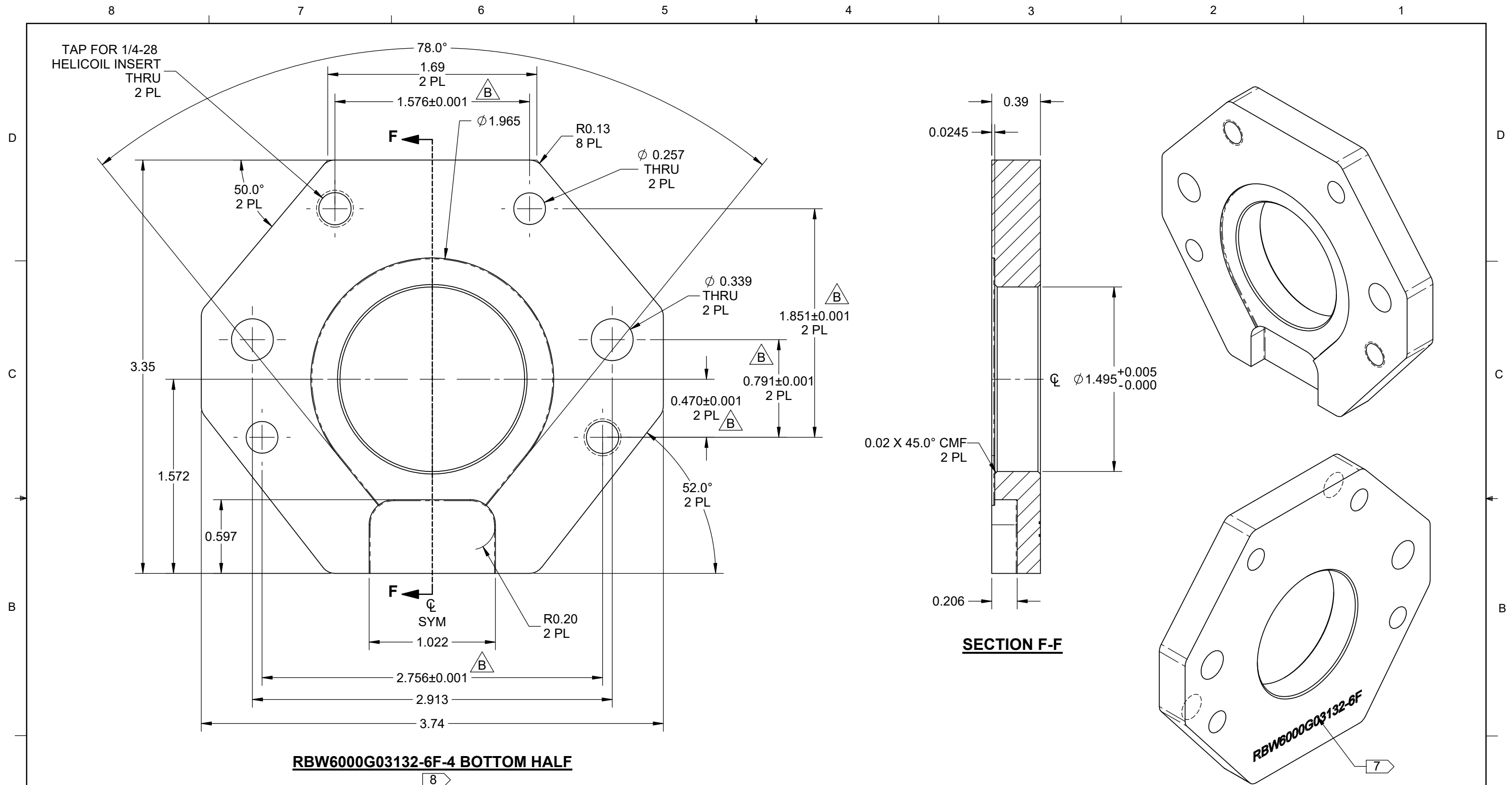
NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: N/A
7) ASSEMBLE AS SHOWN. APPLY RED LOCTITE (262) DURING INSTALLATION OF MS124-XXX HELICOIL.

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RB	TOOL PART #	REV. B
MFG. APPR.	DD	RBW6000G03132-6F	SHEET 2 OF 9
APPROVED	SAD	TITLE	SCALE
DATE 6/28/2022		PITCH LINK VISE ASSY	NTS
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- NOTES:
- 1) MATERIAL: 6061-T6 / 7075-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A
 - 8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.005" PER CAD FILE RBW6000G03132-6F-2 REV. B2.STEP

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RB	TOOL PART #	REV. B
MFG. APPR.	DD	RBW6000G03132-6F	SHEET 3 OF 9
APPROVED	SAD	TITLE	SCALE
DATE 6/28/2022		PITCH LINK VISE ASSY	NTS
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NOTES:
1) MATERIAL: 6061-T6 / 7075-T6
2) HEAT TREAT: N/A
3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RBW6000G03132-6F", AS SHOWN
8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.005" PER CAD FILE RBW6000G03132-6F-4 REV. B.STEP

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RB	TOOL PART #	REV. B
MFG. APPR.	DD	RBW6000G03132-6F	SHEET 5 OF 9
APPROVED	SAD	TITLE	SCALE
DATE 6/28/2022		PITCH LINK VISE ASSY	NTS
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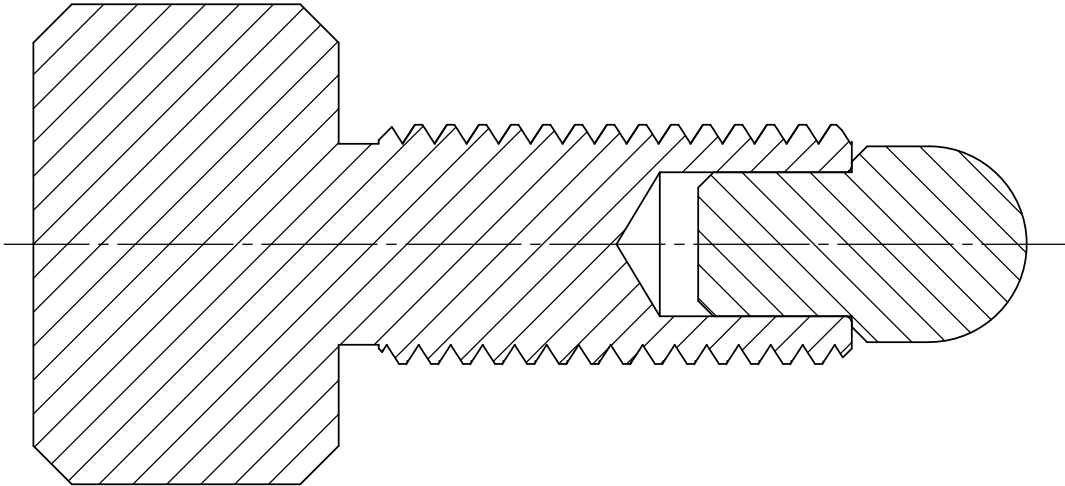
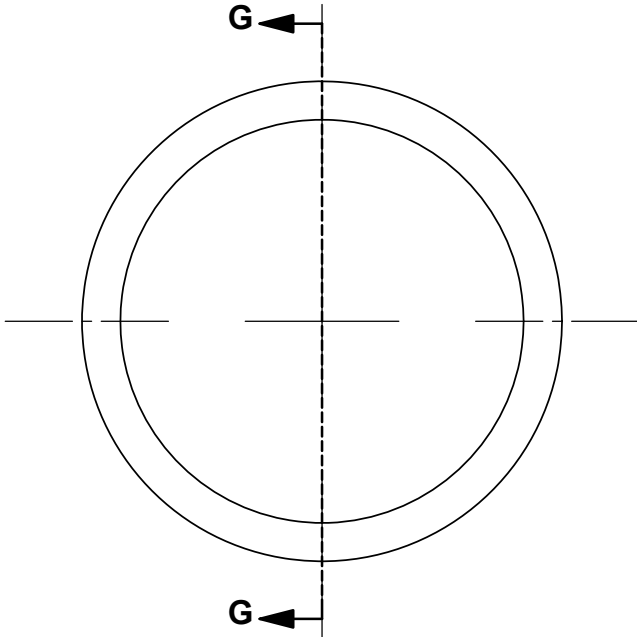
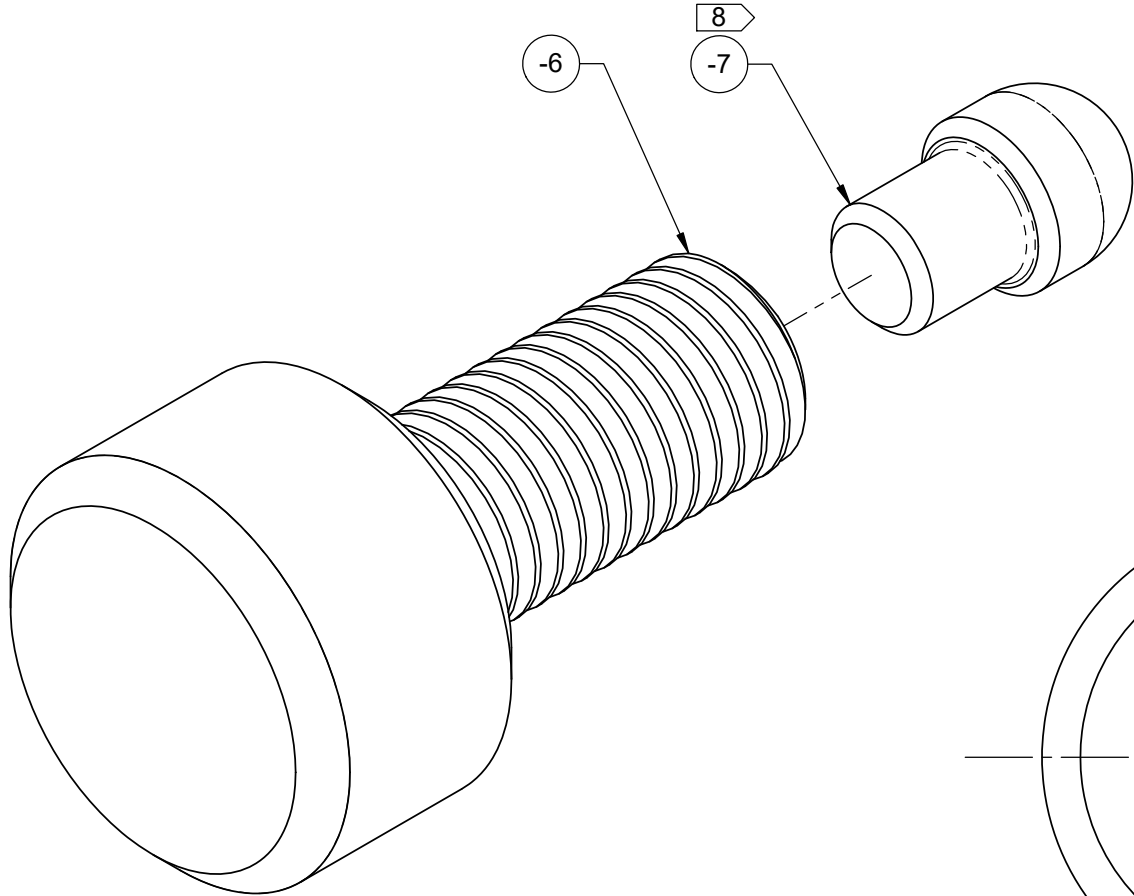
ITEM #	QTY	PART #	PART TITLE
-6	1	RBW6000G03132-6F-6	ALIGNMENT PIN
-7	1	RBW6000G03132-6F-7	TIP

D

C

B

A



SECTION G-G

RBW6000G03132-6F-5 ALIGNMENT PIN ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM -7 WITH ITEM -6, AND REMOVE EXCESS

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RB	TOOL PART #	REV. B
MFG. APPR.	DD	RBW6000G03132-6F	SHEET 6 OF 9
APPROVED	SAD	TITLE	SCALE
DATE 6/28/2022		PITCH LINK VISE ASSY	NTS
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